

Work Order ID 144311

April 12, 2016 11:20:24 AM

144311

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Item ID: 647.3803 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Cutter Assembly
 Start Date: 4/18/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/6/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SA Date: 20160412 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.3800	n/c								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.								
	A/R LOCTITE 598: <u>134524</u>								
	exp. date: <u>09/13</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
36
9-89

DAS
36
9-89

DAS
38
9-89

MAY 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Item ID: 647.3803**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Lower Cutter Assembly**Stop *NS2*****Start Date:** 4/18/2016 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 5/6/2016 **Req'd Qty:** 1.00***1*****Customer:****Reference:**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CCK 029</u>	0.00				1			
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

ML5 MAY 04 2016

ML5 MAY 04 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 144311

144311

Parent Item: 647.3803

647 3803

Parent Item Name: Lower Cutter Assembly

Start Date: 4/18/2016

Required Date: 5/6/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701		Manufactured	No			110	Each	13.0000	1	1			
646 9701									**				DAS 6 9-89
Cutter Sub Assembly													

Location	Loc Qty	Loc Code
cck012	13	
141900	7	
142645	3	
142646	3	

NAS1149FN832P Purchased No 110 Each 2,591.000 6 6

NAS1149FN832P

Washer

Location	Loc Qty	Loc Code
GA	475	
M133316	16	
M133769	459	
ST260a	1200	
M134257	1200	
ST262	916	
M133709	916	

APR 26 2016

Picklist Print

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Parent Item: 647.3803

647 3803

Parent Item Name: Lower Cutter Assembly

Start Date: 4/18/2016

Required Date: 5/6/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

110

Each

1,247.000

3

3

MS21042I 08

Nut

DAS

6

9-89

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

319

m133134

3

m134063

316

ST303

427

m133922

227

m134574

200

ST308

400

m134376

400

3

MS27039-08-19

Purchased

No

110

Each

553.0000

3

3

MS27039-08-19

Screw

DAS

6

9-89

Location

Loc Qty

Loc Code

CCK06

200

m134142

200

GA

227

m132930

84

m133077

22

m134063

121

over006

100

m134294

100

ST277

26

m133769

26

2

647.3901

Manufactured

No

110

Each

0.0000

1

1

647 3901

Lower Deflector Assembly, Low

DAS

36

9-89

B44318 (K)

16/05/03

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Shop Packet Print

Page 2

1. IDENTIFY IAW MPP-120
2. APPLY F/N 9 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 5, 6, 7, & 8 UPON ASSEMBLY

26730412
54 144311

				1		9	647.3911	212 UPPER DEFLECTOR			
					1	8	647.3910	412 UPPER DEFLECTOR			
	A/R	A/R	A/R	A/R		7	601.2045	RTV. LOCITE 598			
	1					6	647.3902	LOWER DEFLECTOR ASSY HIGH			
		1				5	647.3901	LOWER DEFLECTOR ASSY LOW			
	3	3	3	3		4	601.2765	SCREW	MS27039-0019		
	3	3	3	3		3	601.1541	LOCKNUT	MS21042L306		
	6	6	6	6		2	601.2764	WASHER	F14S1149FN832P		
	1	1	1	1		1	646.9701	CUTTER SUB ASSY			
							647.3804	LOWER CUTTER ASSY HIGH			
							647.3803	LOWER CUTTER ASSY LOW			
							647.3802	212 UPPER CUTTER ASSY			
							647.3801	412 UPPER CUTTER ASSY			
	3804	3803	3802	3801	FIND #		PART #	DESCRIPTION	MATL	SPEC	
QTY						PART LIST					
NEXT ASSY (\$)						ORIGINAL DATE: 07/20/00 DRAWN BY: J. JACKSON CHECKED: D. BARNES PERFORMING APPROVAL: B BY: BLAKE GROUP: 000000 CONTRACT NO:					
647.3700						APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300					
						CUTTER ASSY					
						REF: CAG4 CODE: 07M4Z DWG NO: 647.3800 B SCALE: NONE SHEET: 1 OF 1					